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TI SURFACE HARDENING METHOD FOR END PART OF CYLINDRICAL MEMBER BY HIGH
FREQUENCY HARDENING
IN ONISHI MASAZUMI
PA TOYOTA MOTOR CORP
PI **JP 61261423 A** 19861119 Showa
AI JP 1985-100090 (JP60100090 Showa) 19850511
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SO PATENT ABSTRACTS OF JAPAN (CD-ROM), Unexamined Applications, Vol. 1986
AB PURPOSE: To prevent a quenching crack and to increase the depth of
hardening by heating the end part of a cylindrical member to the
austenitizing temp. by high frequency heating with a hardening coil placed
opposite to the end part thereof and by immediately spraying a quenching
medium on the end, the inside and outside periphery of the end part to
cool them.
CONSTITUTION: The end part of a cylindrical metallic member is heated to
the austenitizing temp. by high frequency heating with a hardening coil
placed opposite to the end of the end part at about 2mm interval while the
member is turned around its axis at about 100r.p.m. A cooling medium is
then sprayed at once on the end, the inside and outside periphery of the
end part at 10~150l/min rate to cool them.
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